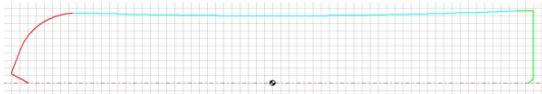


Gear Insert A L64 B17 H9.65

A08-010

After probing sideposition of the insert, 2 passes of pregrinding and 2 passes of finishing are executed. K-Land is ground in one pass on each side with periphery of a 20° wheel.



1. Cycletime for Production

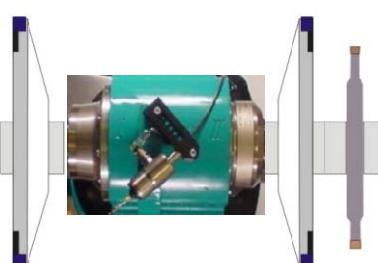
Workpiece:	Blank L65xB17.5xH10 Material CARBIDE					
Operations	Probe	Pregrinding	Finish	Kland right	Kland left	Load
Feed [mm/Min]	2000	30	30	90	90	9000
Power [kW]		3	1	1	1	1
Cutting speed [m/s]		22	22	22	22	
Used wheels		1	2	3	3	
Grinding time [s]	12	421	210	45	45	14
Total cycle time	12 Min 28					

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.



2. Used Grinding Wheels

1	12C9 Ø300 D91 C100
2	12C9 Ø300 D64 C125
3	DXF Ø150 D54 2xV20°



3. Machine and Software Requirements

Machines: 5 axes CNC grinders : SIRIUS HPM

Coolant: Synthetic Oil, pressure 6 bar

Control: Fanuc 310i

Software: Quinto 5

Accessories: special Clamping, Steady Rest

Responsible engineer: OP, 21.5.15

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